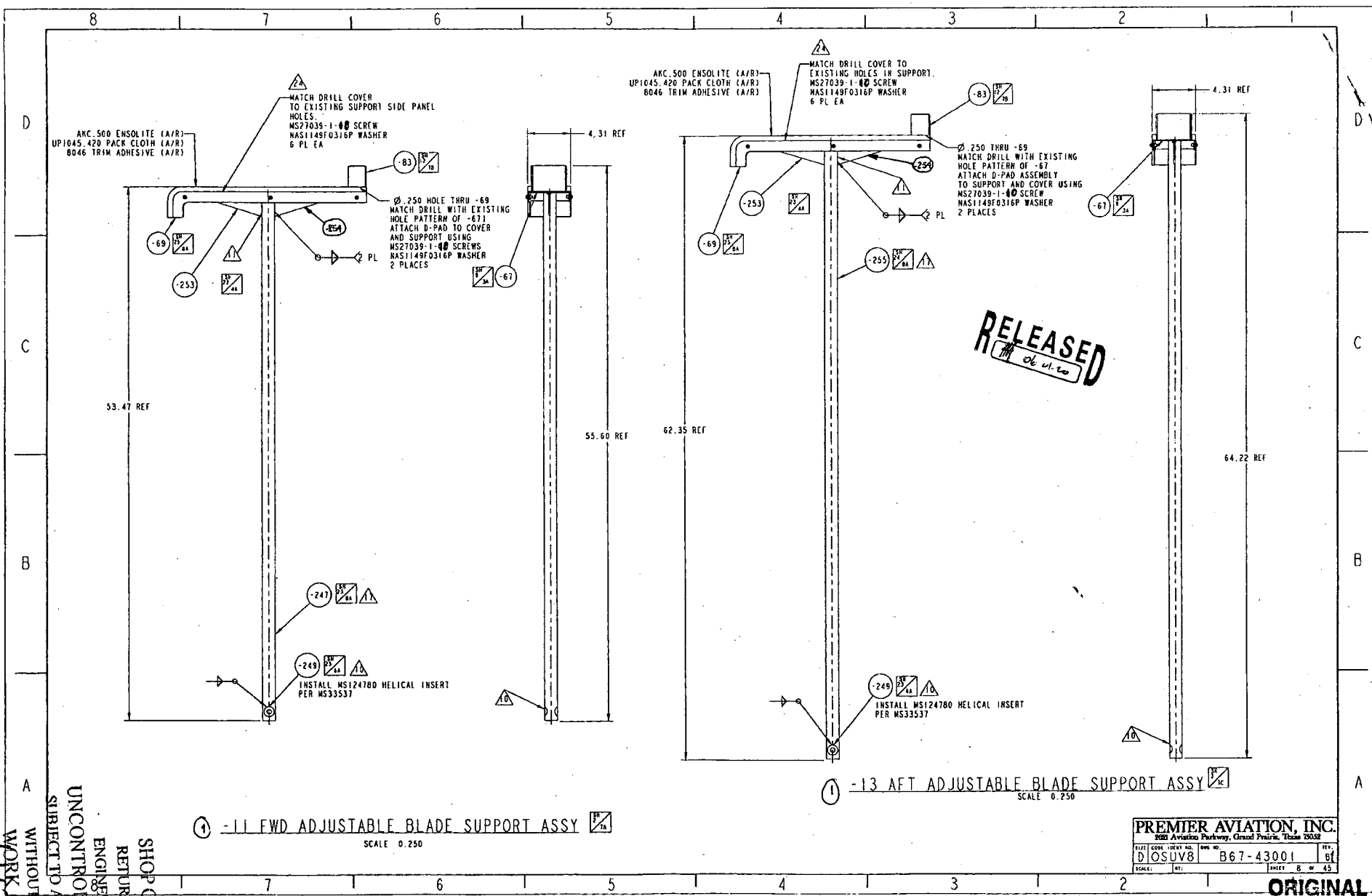


NO. 41305  
 WORK ORDER  
 WITHOUT NOTICE  
 SUBJECT TO AMENDMENT  
 UNCONTROLLED COPY  
 RETURN TO  
 ENGINEERING  
 SHOP COPY



PREMIER AVIATION, INC.  
 3000 Aviation Parkway, Grand Prairie, Texas 75050  
 FILE NO. 867-43001  
 SCALE: 1/8" = 1"

ORIGINAL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:44:26 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 41365

Part Number: PB674300111

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/23

(X2)

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Cont welding

08/10/23

(X2)

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/23

Job Completion



MF 08-10-23

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

Date: Monday, 18/08/2008 3:44:26 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 41365

Part Number: PB674300111

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:00  
320 OF  
9:30

M-L

08/29/30

(2X)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



218



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-09-30

(2)

15.0

PB674300169

90 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

90 Degree Cover Plate

batch:

41511

x 4

Cpl 08-10-22

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

PB67-43001-83

batch:

~~B-40096~~ x 4

x 4

41516  
~~B-41516~~ x 4

Cpl 08-10-22

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 64.0000 Each(s)

Screw

batch:

m109031

x

Cpl 08-10-22

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 64.0000 Each(s)

WASHER

batch:

m109031

Cpl 08-10-22

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg

M-L / Cpl 08-10-22

(X4)

(72)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 18/08/2008 3:44:26 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 41365

Part Number: PB674300111

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

*LF 08.09.29 2*

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PL 08.09.29*

*RF 08.09.29*

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 08.09.29 (42)*

9.0

MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

HELICAL INSERT

*M11935*

*LF 08.09.29*

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush in area of PB67-43001-249 only

2- install helicol insert as per dwg

*LF 08.09.29*

*LF 08.09.29*

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 08.09.29 (42)*

12.0

HAND FINISHING1

HAND-FINISHING-RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*1 A S 08.09.30*

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

*M-L 08/09/30*

*(2X)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Monday, 18/08/2008 3:44:26 PM

Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	FWD ADJUSTABLE BLADE SUPPORT ASSY
<b>Job Number</b> :	41365		
<b>Estimate Number</b> :	13435		
<b>P.O. Number</b> :		<b>Part Number</b> :	PB674300111
<b>This Issue</b> :	18/08/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	B6743001 P.8
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	40606	<b>Drawing Revision</b> :	B1
	<b>Type</b> :	<b>Material</b> :	
	LARGE FAB ASSY	<b>Due Date</b> :	18/09/2008
<b>Written By</b> :		<b>Qty:</b>	8 Um: Each
<b>Checked &amp; Approved By</b> :	<i>J.D. 08.8.18</i>		
<b>Comment</b> :	Est Rev:A 08-06-26 new issue DD verified by:ec		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PB6743001247	Inner Tube
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Inner Tube

batch: *4/491*

2.0	PB6743001249	Inner Tube Bushing
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Inner Tube Bushing

batch: *M18147*

3.0	PB6743001253	Gusset
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Gusset

batch: *340717 41492*

4.0	PB6743001254	Gusset
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Gusset

batch: *340053 41493*

5.0	PB674300167	PB67-43001-67
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

PB67-43001-67

batch: *41214*